

Work Order ID 60958

July 29, 2010 11:03:33 AM



Page 1

PRELIMINARY ISSUE

Item ID: D4055-043

Accept



Setup

Start



Revision ID:

Item Name: Aux Tank

Stop



Start Date: 7/29/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4055

AB

100



Large Fab

Memo

MODIFY AS PER DRWG D4055 REV.B
DETAIL-043 D4055-041

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

BS6762

- Weld tabs D4124-1 per Dwg.
- Weld sump D4125-041 per Dwg.
- Install tank support D4062-1 per Dwg.

SP 10/07/09 14

LC 10.07.29 1
100803

QC 9 inspect weld. → BE 10/09/03

QC 5 inspect work to current →
Step. 10/08/03

POSITIVE RECALL
EFFECTIVE 10/07/09 AUTH 11
RELEASED DATE

Conformity Test. 10.07.30
Rev.B with Screen Division

Picklist Print

July 29, 2010 11:03:25 AM

Page 1

Work Order ID: 60958



Parent Item: D4055-043



Parent Item Name: Aux Tank

Start Date: 7/29/10

Required Date: 7/30/10

Comments:

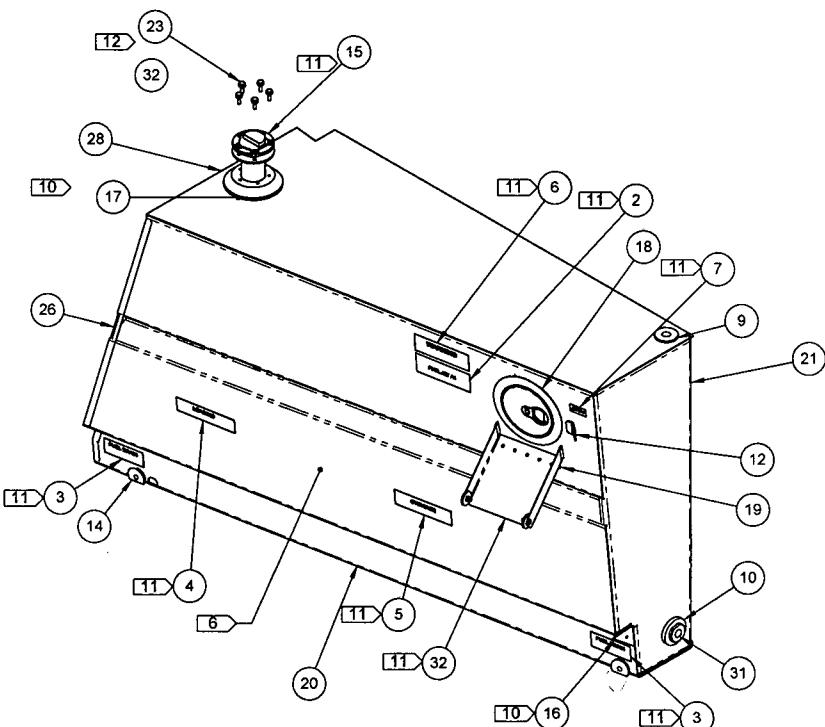
Screw

NAS 1149 D03635

MISSISSIPPI

6 10 07 29 ~~80~~

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-9	ANGLE
9	1	D4000-5	FUEL TANK VENT FITTING
10	1	D4000-1	FUEL SUPPLY FITTING
11	3	D4000-9	GROMMET
12	1	D3999-11	EARTH TAB
13	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
14	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
15	1	D4025-1	FUEL SENDER
16	1	D3999-7	CORNER
17	1	D4001-1	FITTING
18	1	D4023-1	FUEL CAP
19	1	D4008-11	TANK HINGE HALF
20	1	D4055-11	TANK FRONT AND BOTTOM
21	1	D4055-3	TANK AFT END
22	3	D4057-1	RETAINING RING
23	5	AN3H5A	BOLT
24	5	NAS1149D0363J	WASHER
25	1	D4055-9	TANK BACK
26	1	D4055-7	TANK FORWARD END
27	1	D4055-5	TANK UPPER CUT OUT
28	1	D4055-1	TANK TOP
29	1	D3999-041	BAFFLE ASSEMBLY, AFT
30	1	D3999-043	BAFFLE ASSEMBLY, FWD
31	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
32	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY

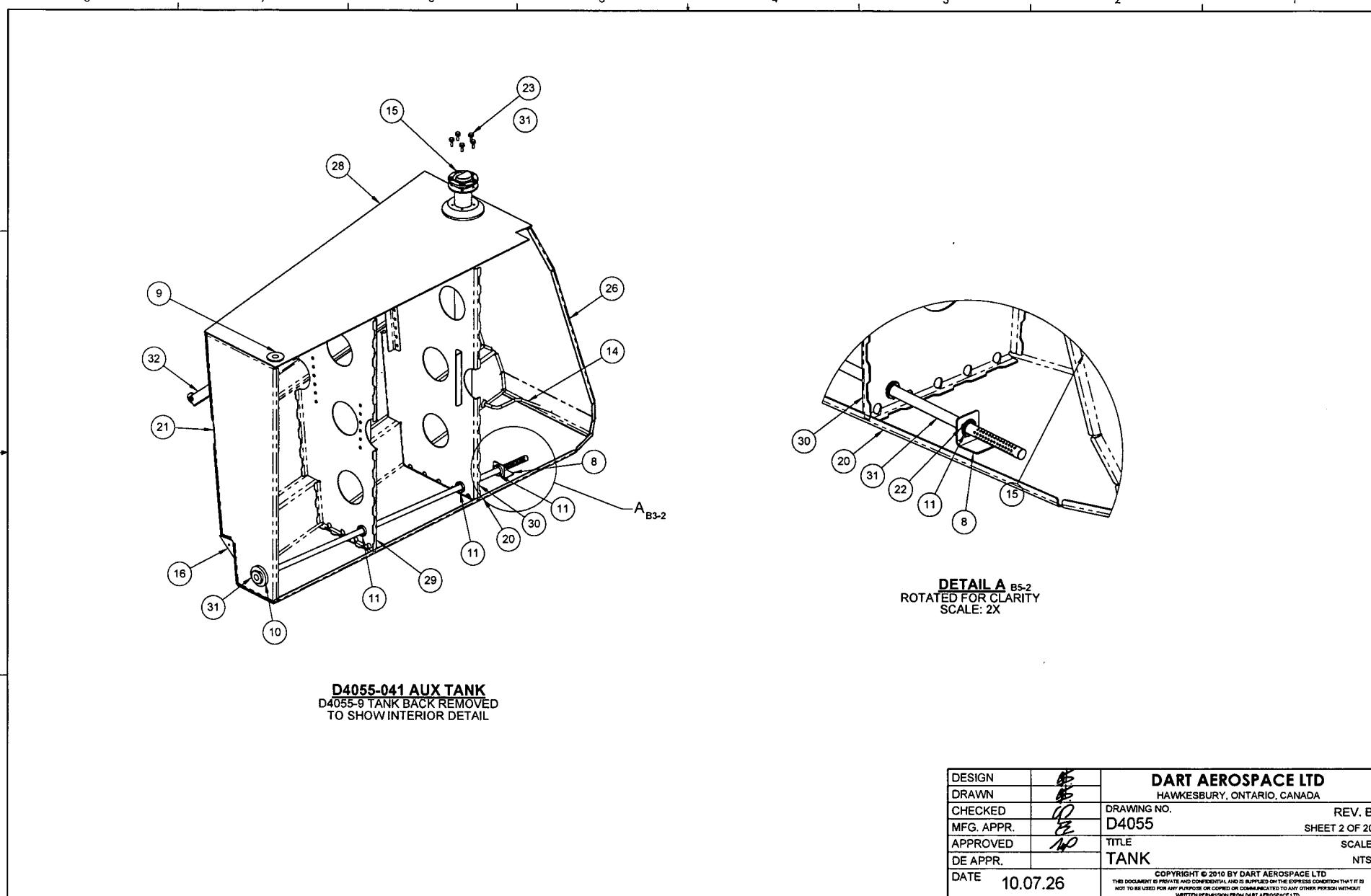


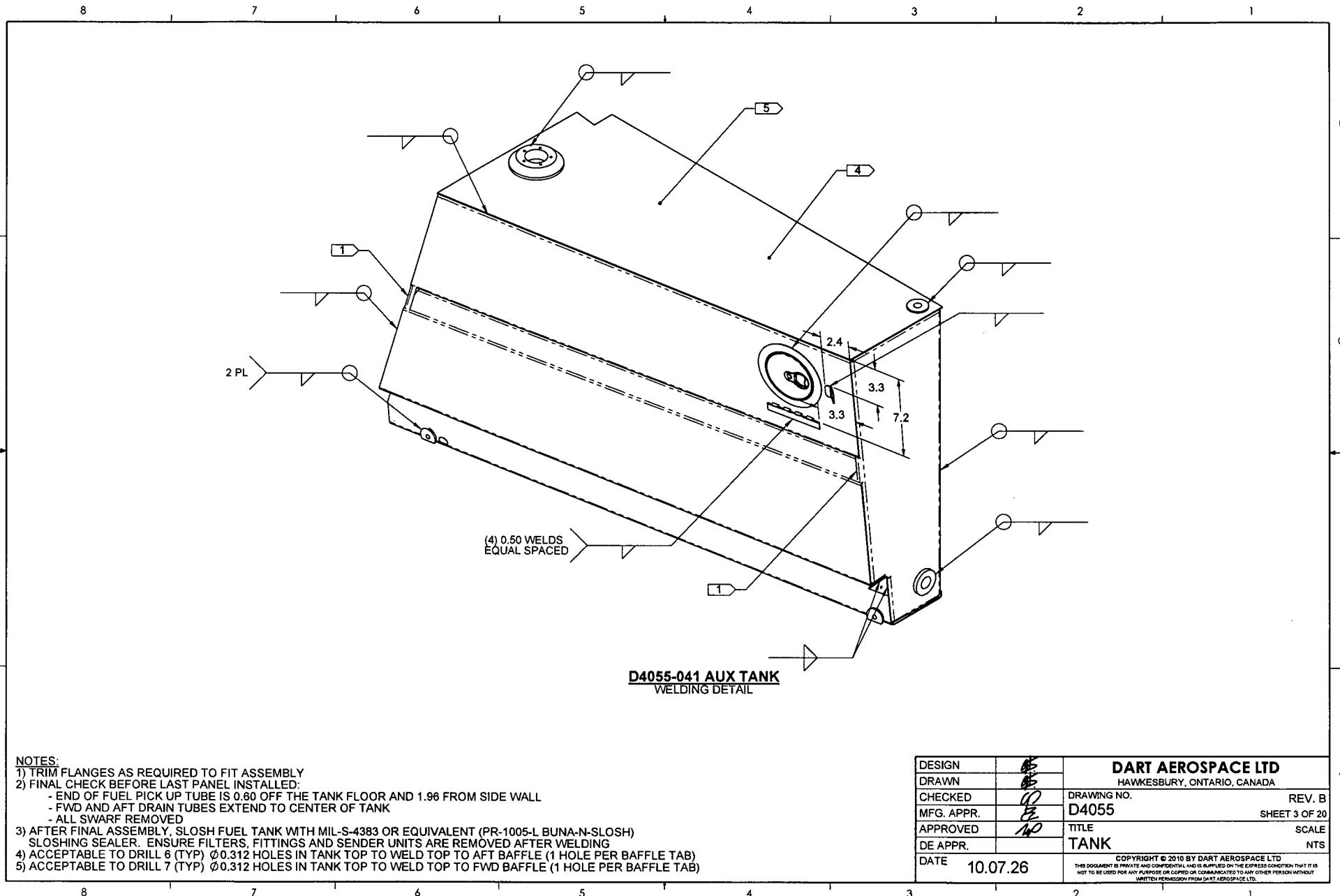
D4055-041 AUX TANK

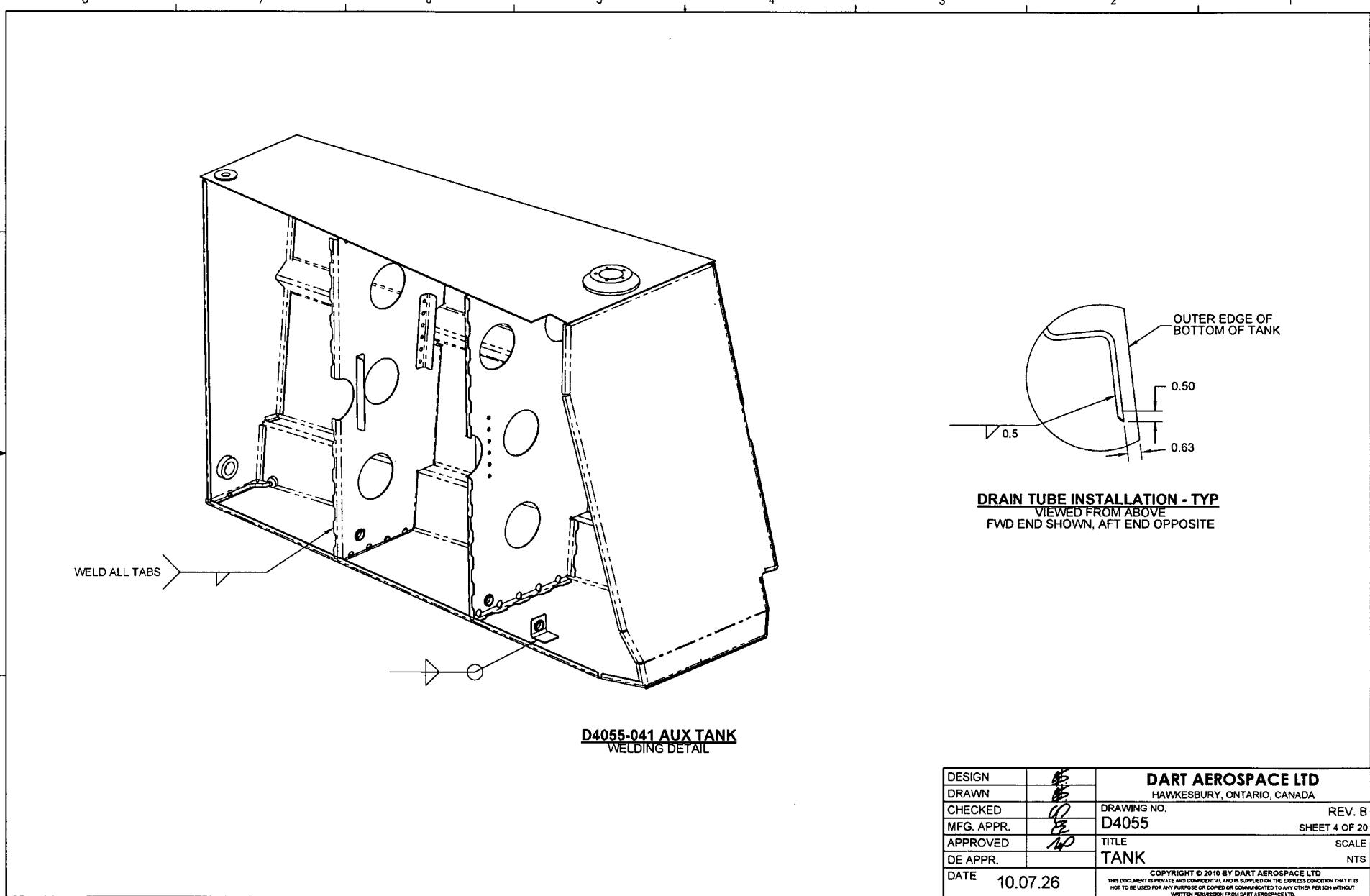
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION

B	ADD-043 ASSEMBLY (SHT 5-7) AND -13 PART (SHT 19-20)	<i>E</i>	10.07.26
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION		
DESIGN	<i>E</i>	DART AEROSPACE LTD	
DRAWN	<i>E</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>E</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4055	SHEET 1 OF 20
APPROVED	<i>E</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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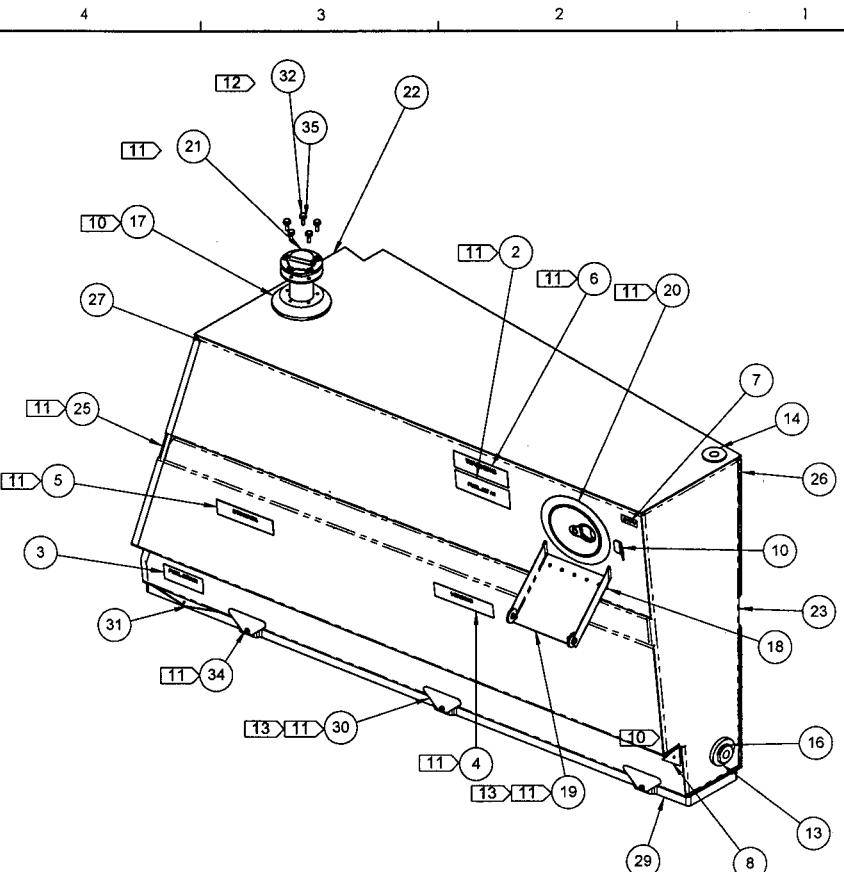
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DRAWN	<i>E</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>P</i>	DRAWING NO.	
MFG. APPR.	<i>E</i>	REV. B	
APPROVED	<i>ND</i>	D4055	
DE APPR.		SHEET 4 OF 20	
DATE	10.07.26	TITLE	SCALE
		TANK	NTS

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ITEM NO.	QTY.	Partno	DESCRIPTION
1	X	D4055-043	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	1	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
17	1	D4001-1	FITTING
18	1	D4008-11	TANK HINGE HALF
19	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
20	1	D4023-1	FUEL CAP
21	1	D4025-1	FUEL SENDER
22	1	D4055-1	TANK TOP
23	1	D4005-3 <i>D4055-3</i>	TANK AFT END
24	1	D4055-5	TANK UPPER CUT OUT
25	1	D4055-7	TANK FORWARD END
26	1	D4055-9	TANK BACK
27	1	D4055-11	TANK FRONT AND BOTTOM
28	3	D4057-1	RETAINING RING
29	1	D4062-1	TANK SUPPORT
30	6	D4124-1	TAB
31	1	D4125-041	FWD SUMP
32	5	AN3H5A	BOLT
33	6	MS21042L3	NUT
34	6	MS35206-250	SCREW
35	11	NAS1149D0363J <i>(+6)</i>	WASHER

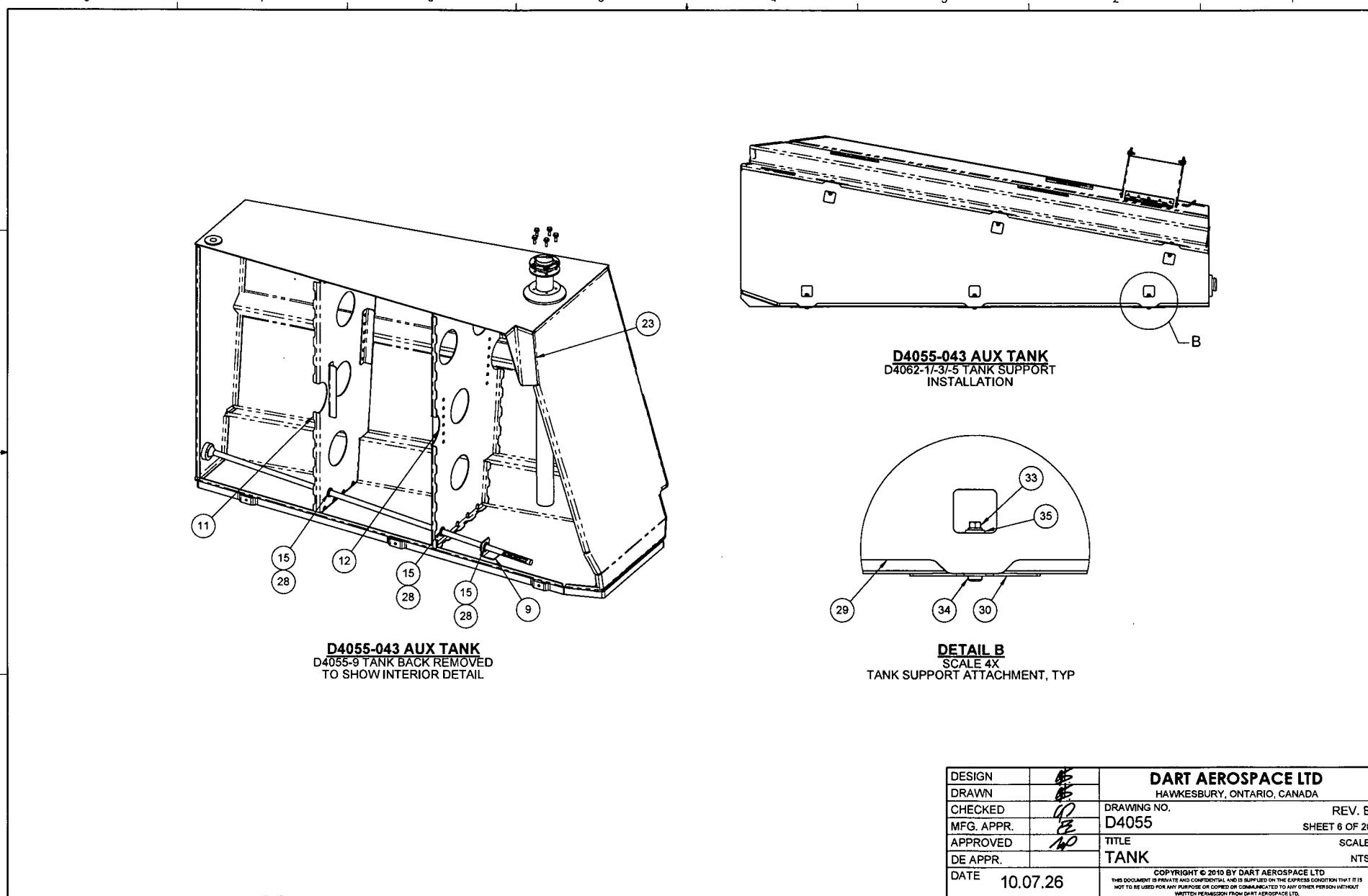
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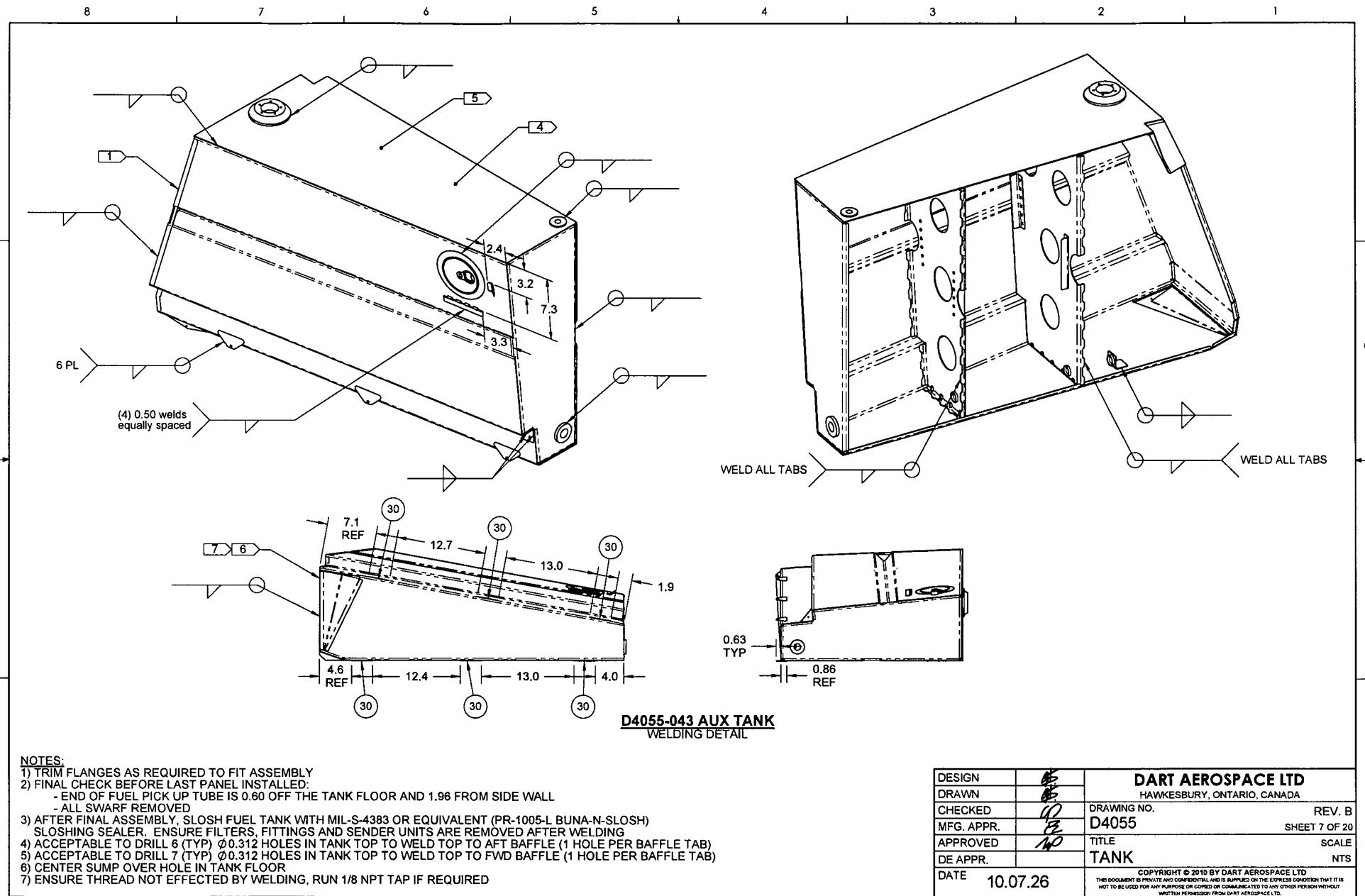
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4,3,5,6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-143" USING D2729-1 RED DECAL
- 7) WEIGHT: 20.45 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION
- 13) IT IS PERMISSIBLE TO HAND FORM THE TABS **(30)** AS NECESSARY TO INSTALL THE TANK SUPPORT **(29)**

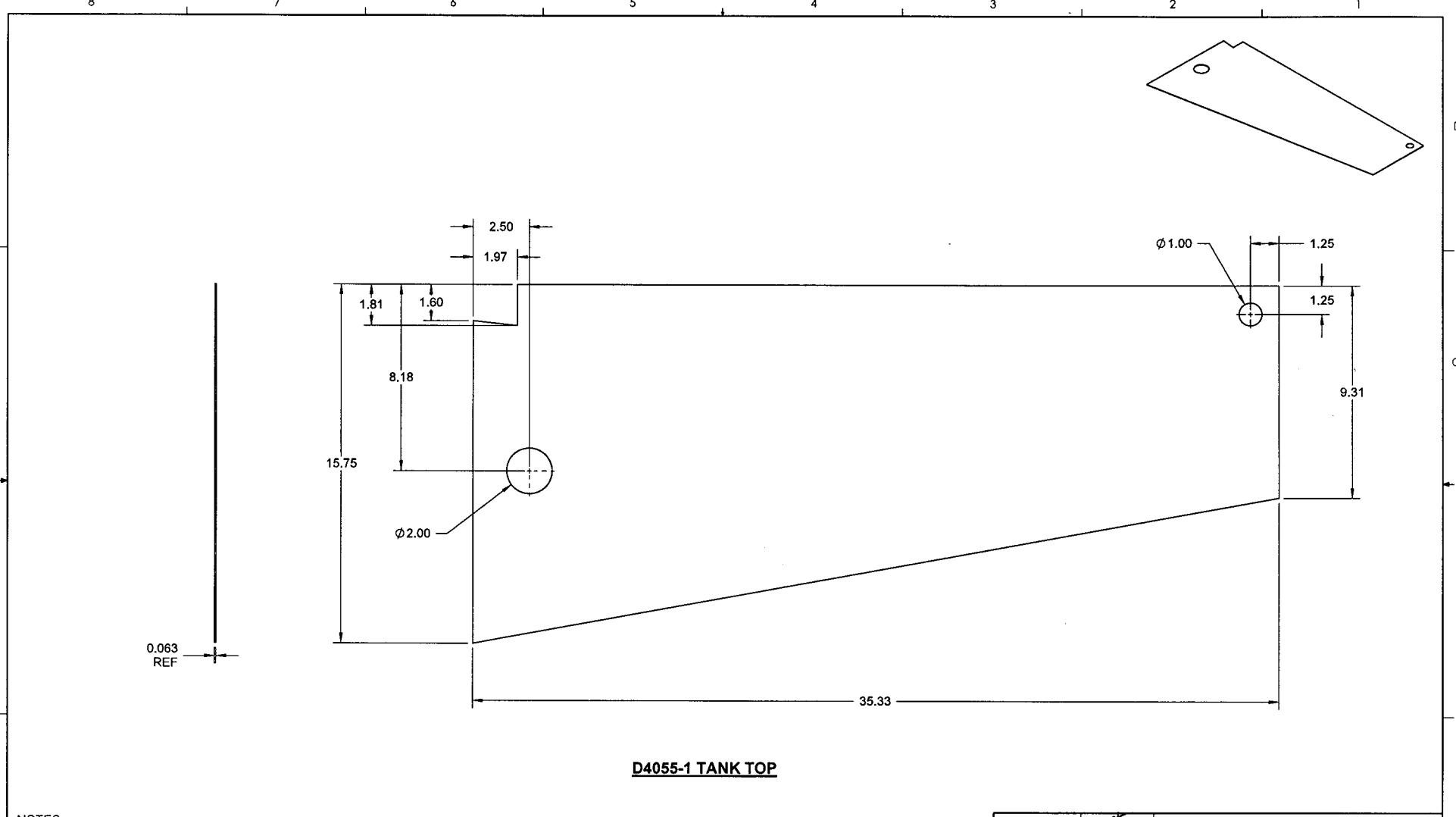


D4055-043 FUEL TANK ASSEMBLY

DESIGN	<i>E</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>E</i>		
CHECKED	<i>E</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4055	
APPROVED	<i>NP</i>	TITLE	SCALE
DE APPR.		TANK NTS	
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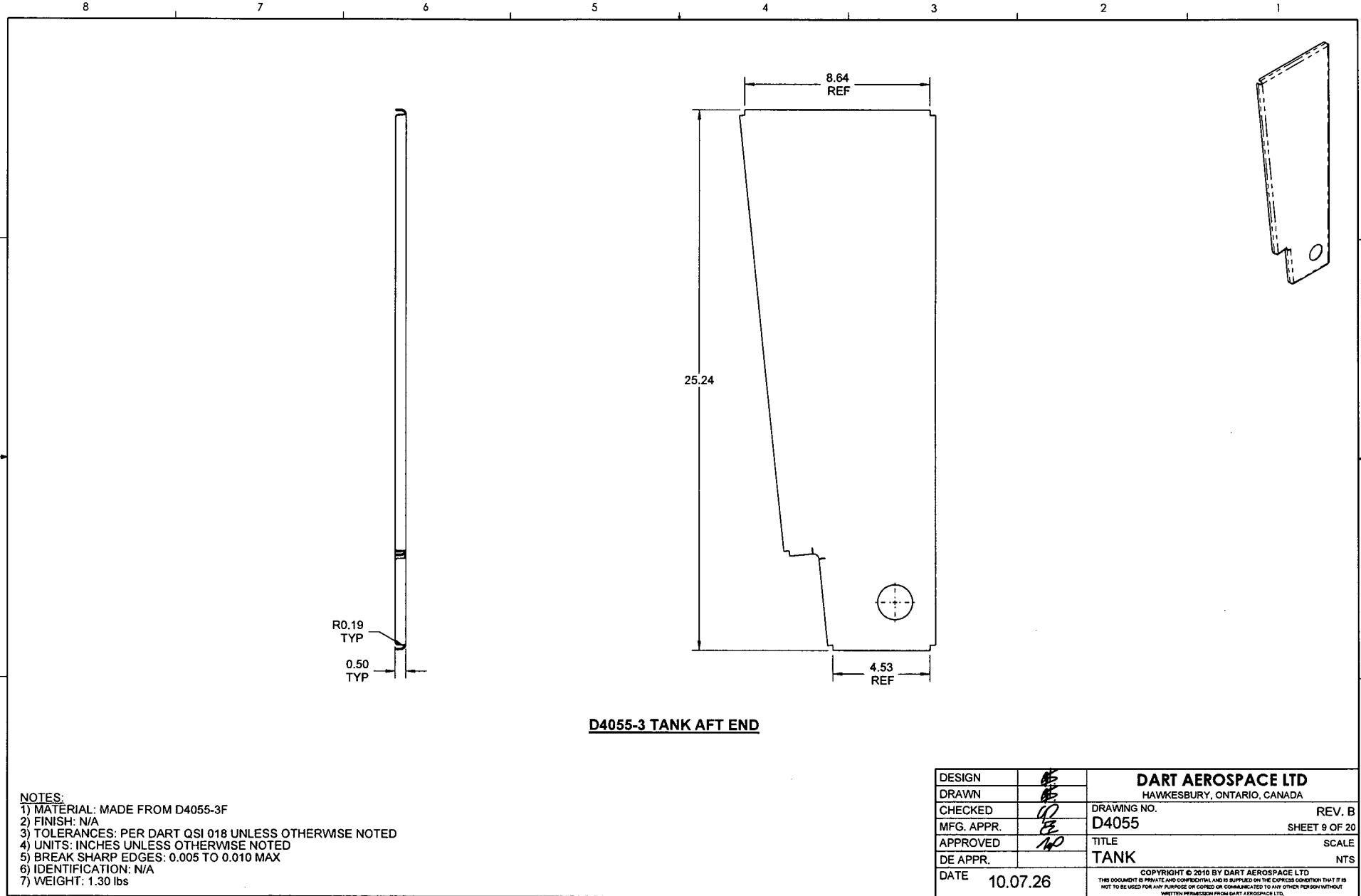


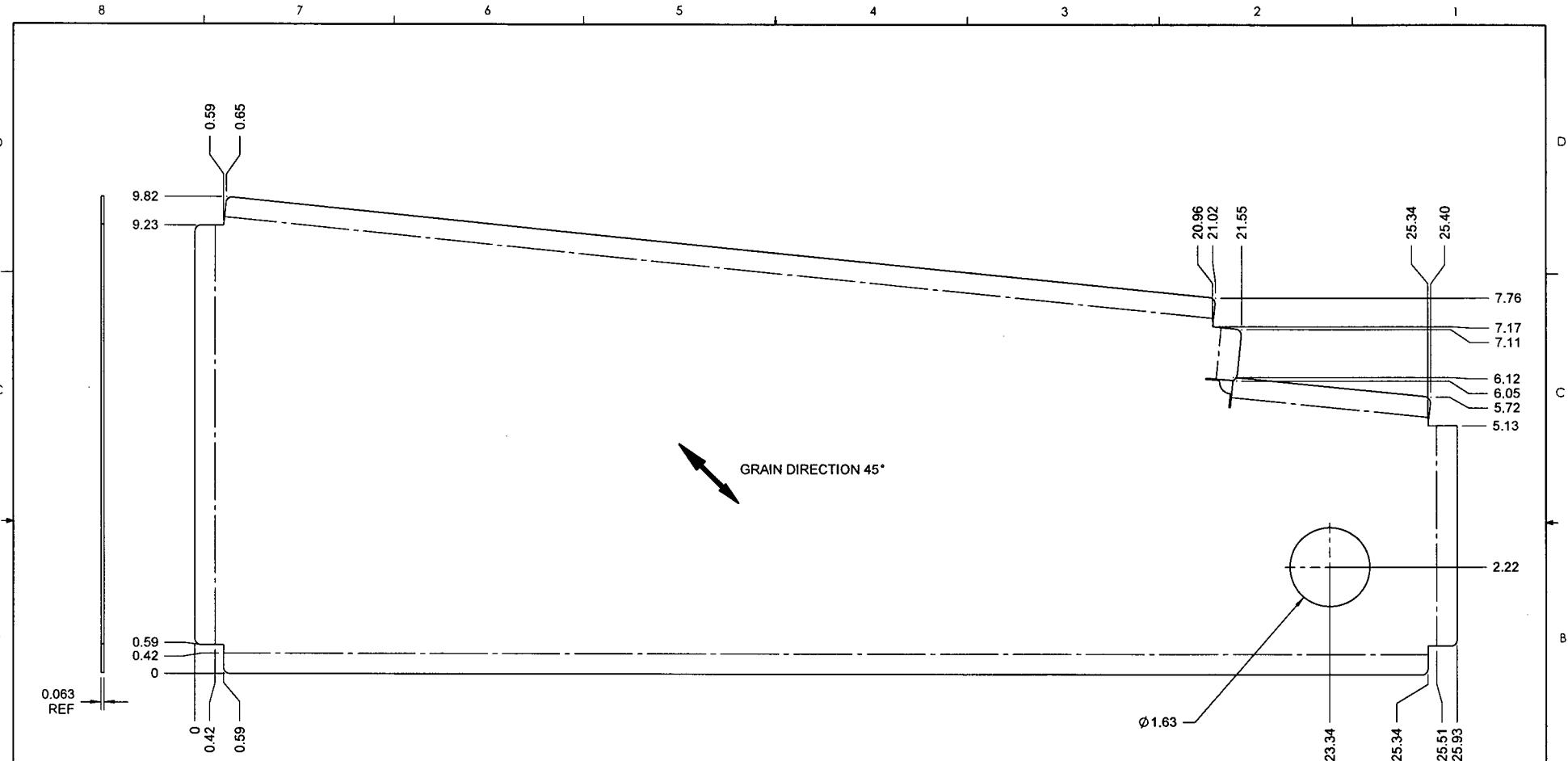
D4055-1 TANK TOP

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	
MFG. APPR.	<i>BS</i>	REV. B	
APPROVED	<i>BS</i>	D4055	SHEET 8 OF 20
DE APPR.		TITLE	SCALE
		TANK	NTS
DATE	10.07.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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D4055-3F FLAT PATTERN

A NOTES:

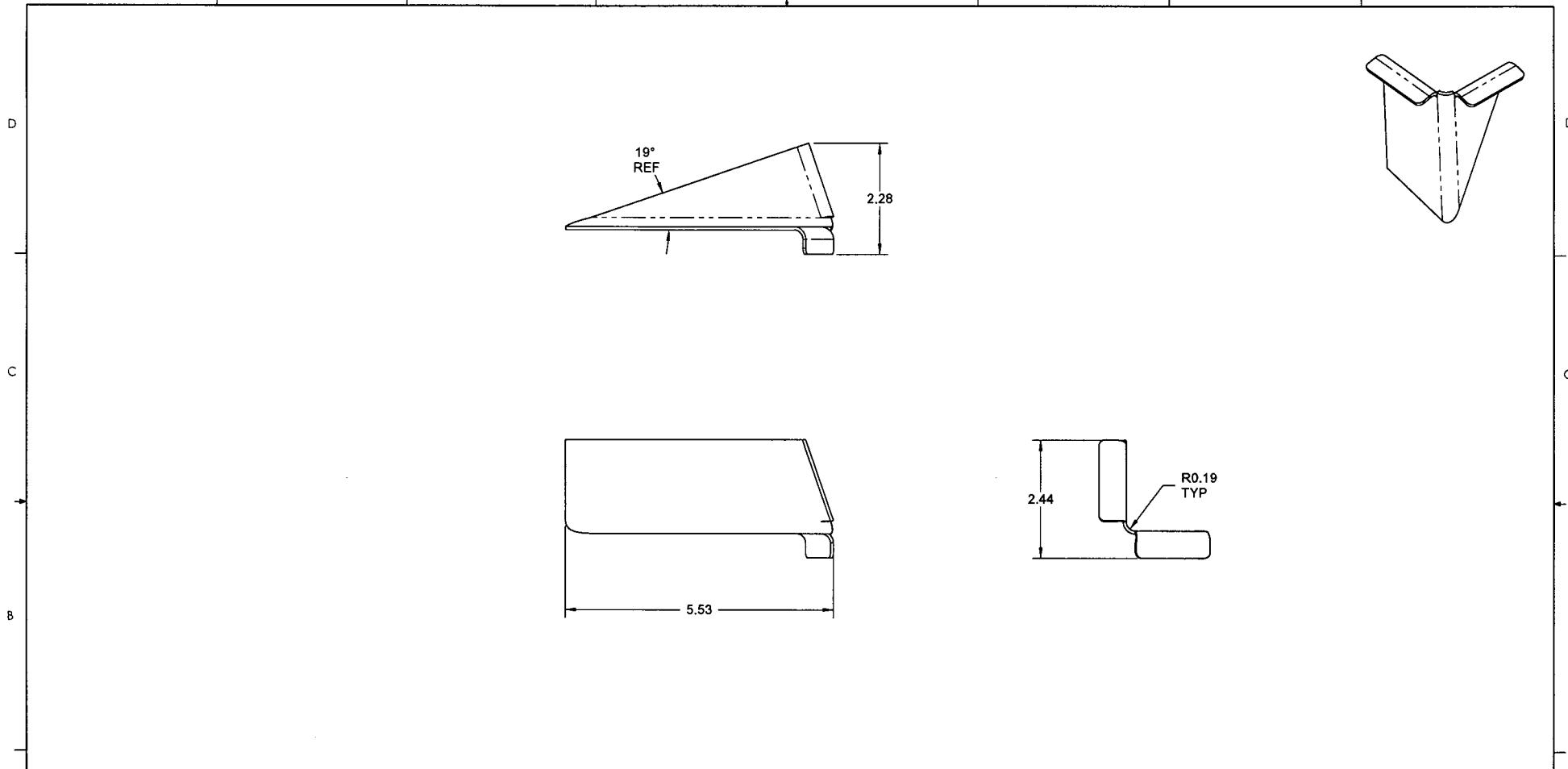
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>BB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BB</i>		
CHECKED	<i>BB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BB</i>	D4055	SHEET 10 OF 20
APPROVED	<i>BB</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4055-5 UPPER CUT OUT

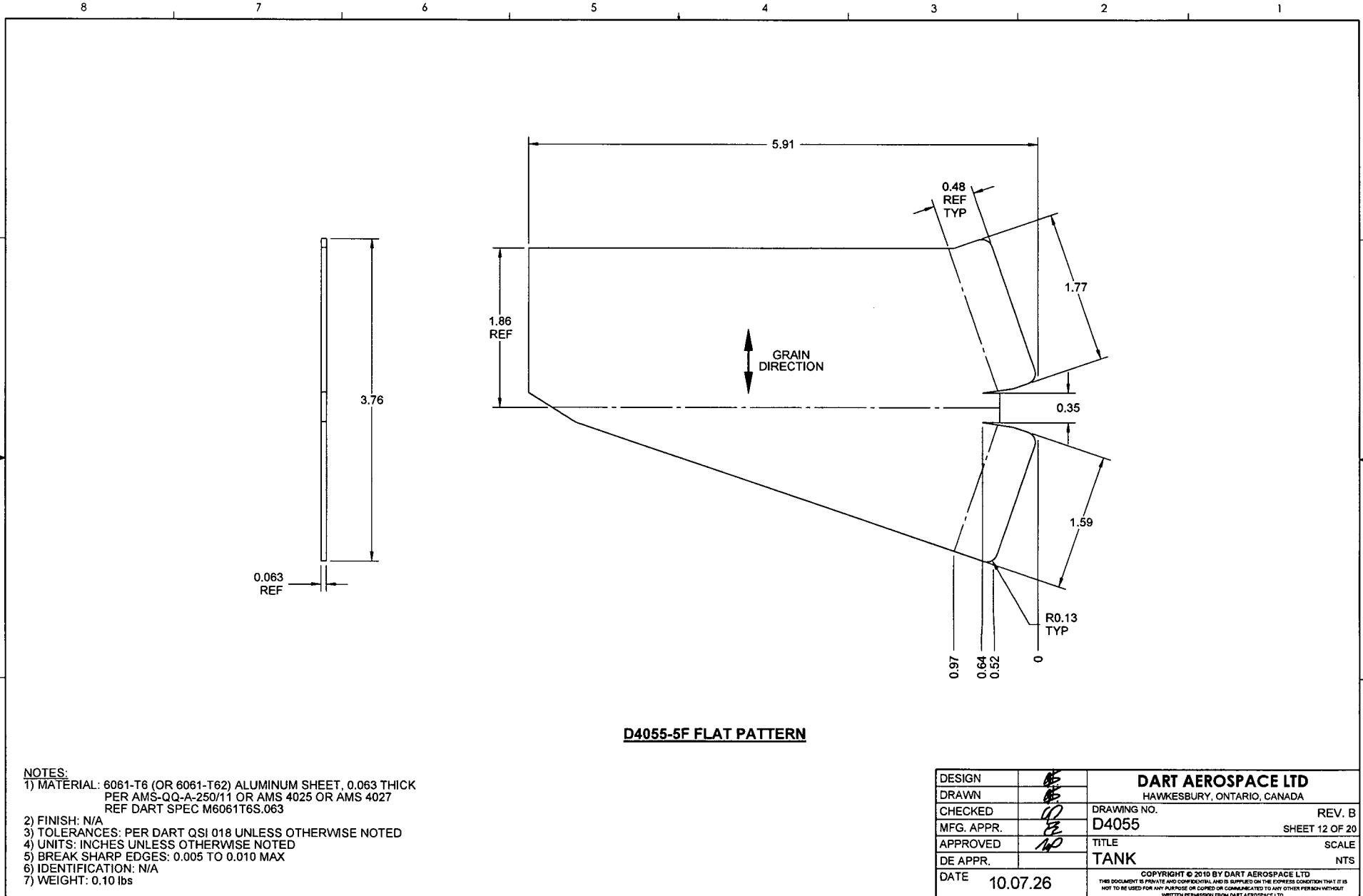
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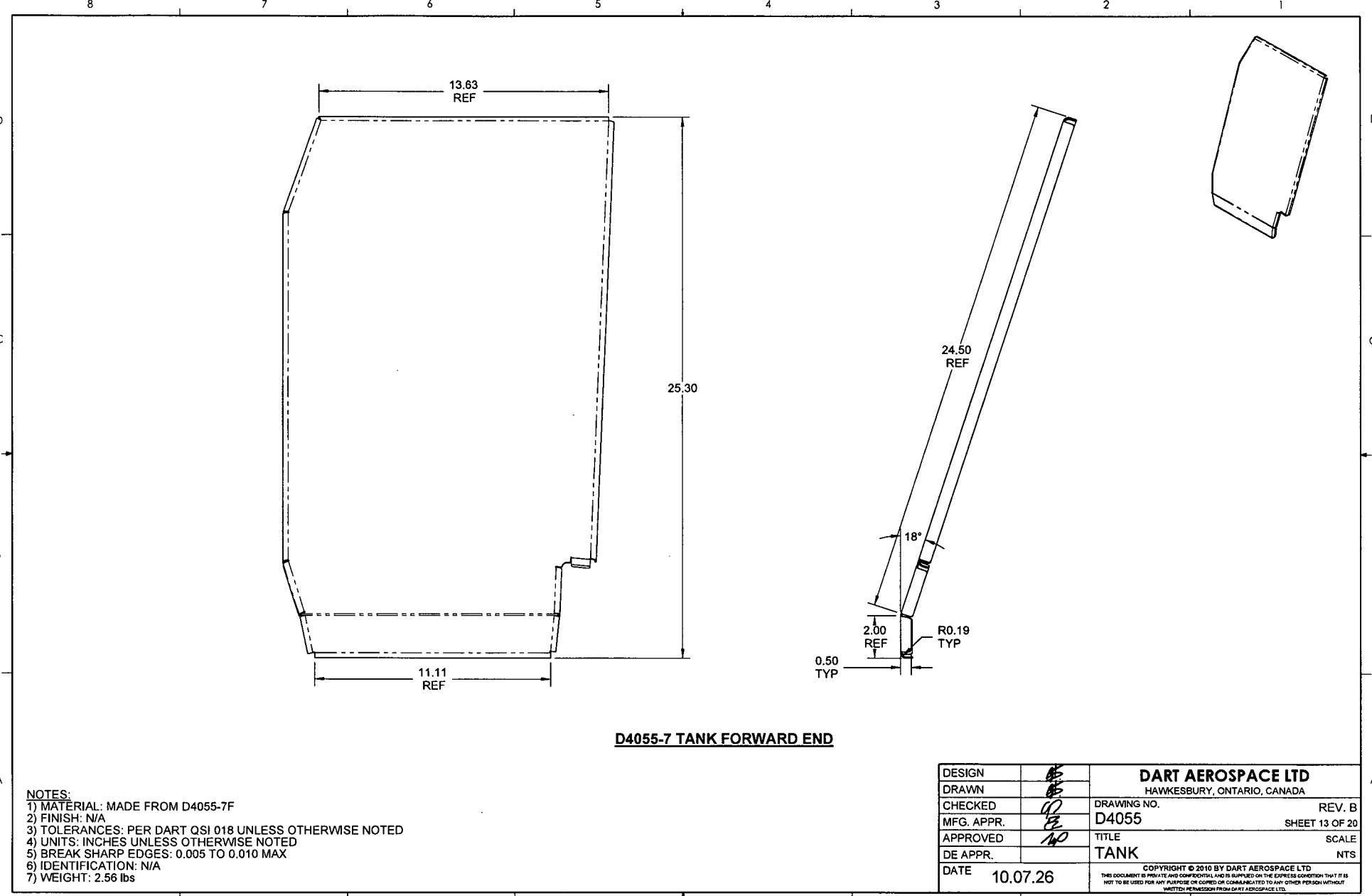
- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

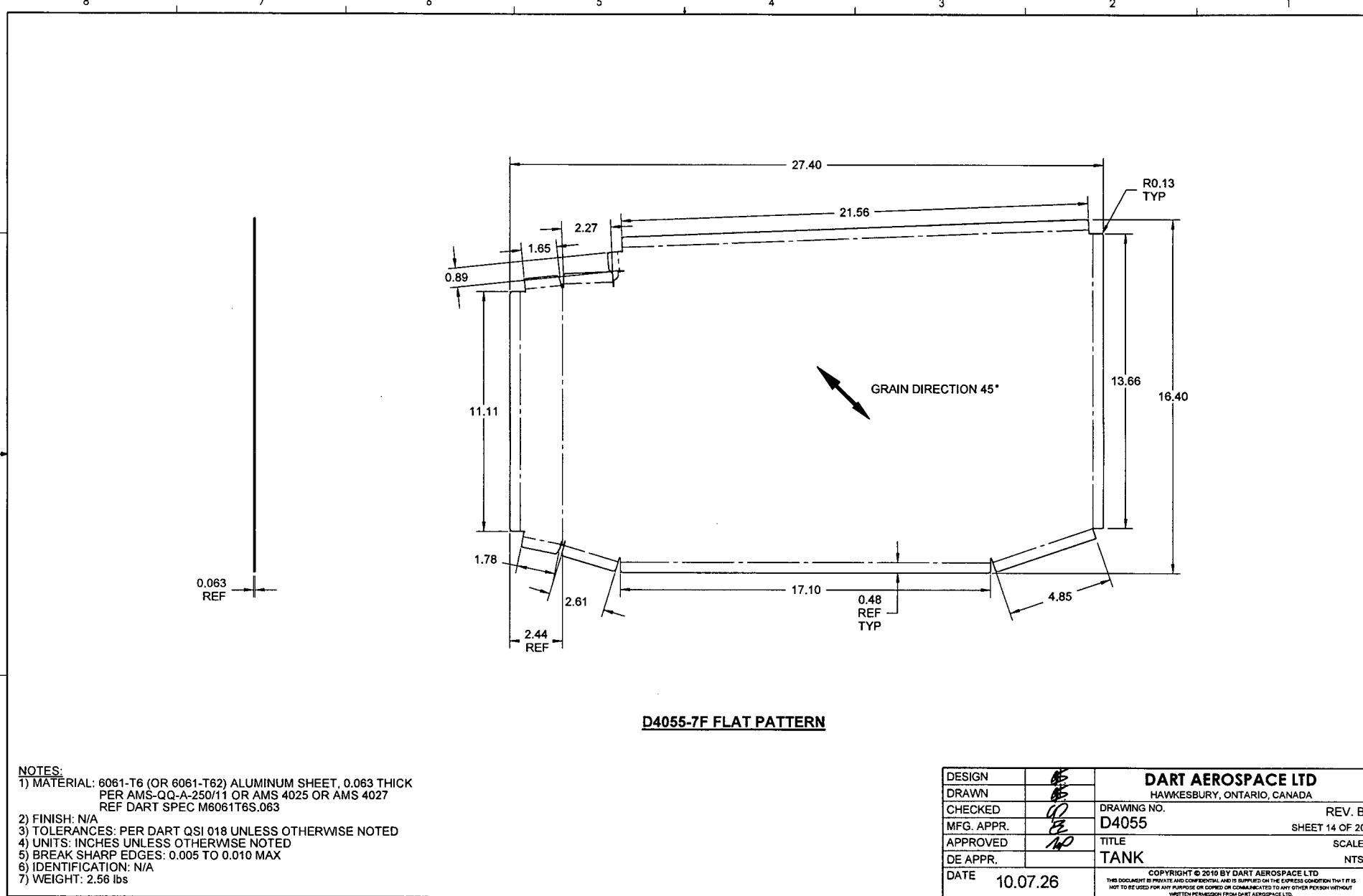
8 7 6 5 4 3 2 1

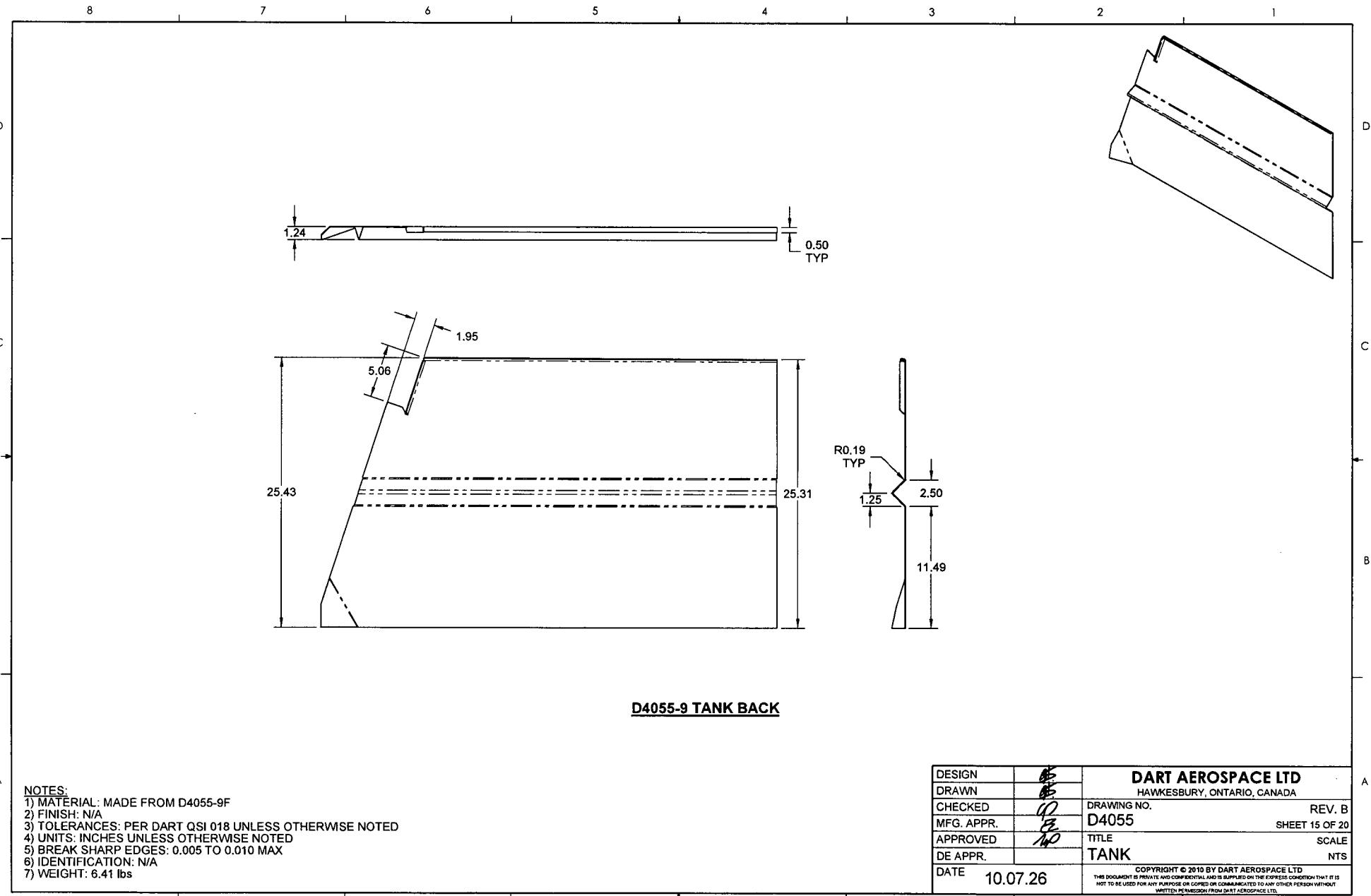
DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO.	
MFG. APPR.	<i>BB</i>	D4055	REV. B
APPROVED	<i>BB</i>	SHEET 11 OF 20	
DE APPR.		TITLE	SCALE
DATE	10.07.26	TANK	NTS

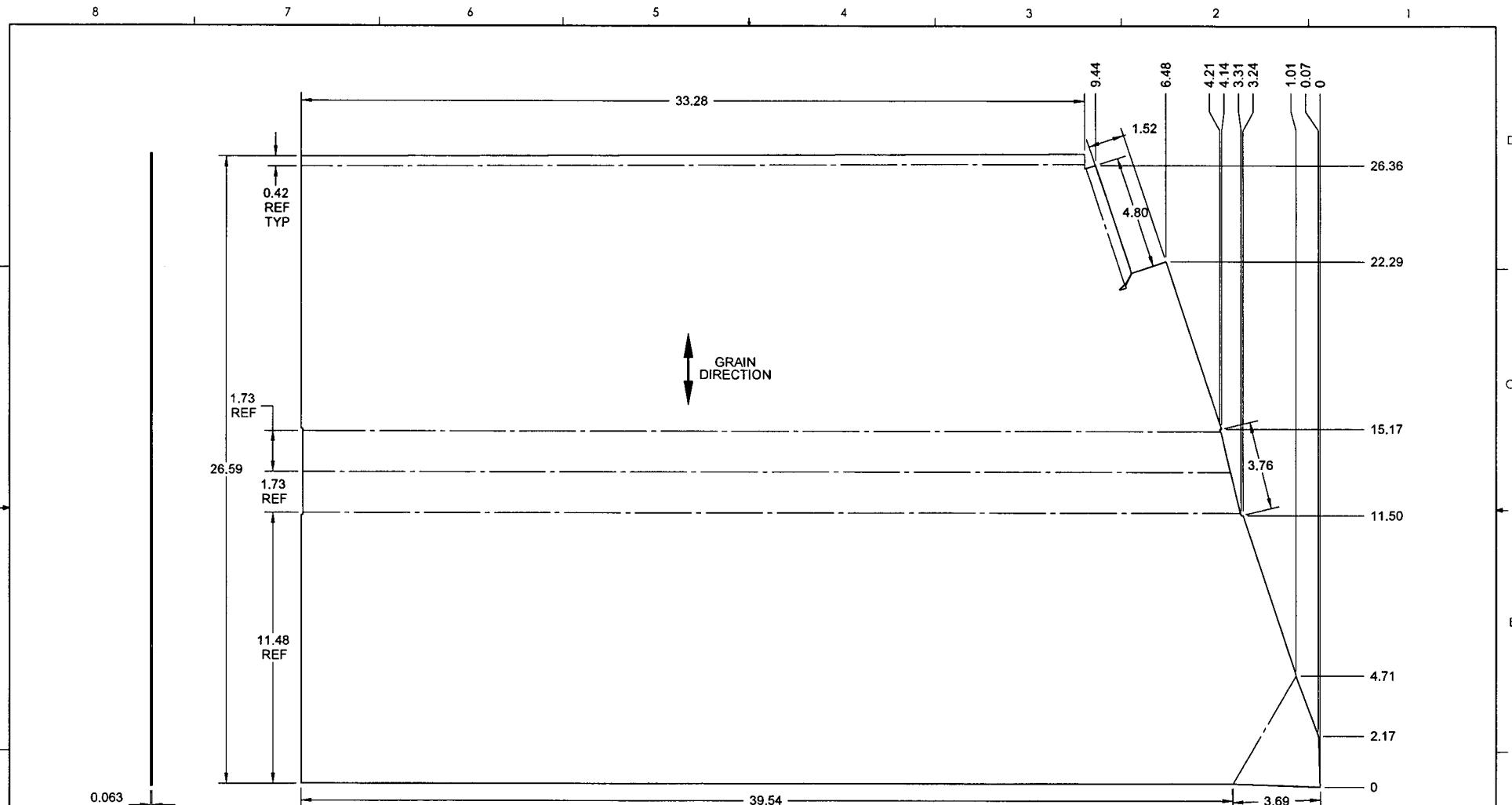
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D4055-9F FLAT PATTERN

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061-T6S.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.41 lbs

DESIGN	<i>BB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>BB</i>			
CHECKED	<i>PP</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>EE</i>	D4055	SHEET 16 OF 20	
APPROVED	<i>NP</i>	TITLE	SCALE	
DE APPR.		TANK	NTS	
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